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D4379-1
Job Sheet 181571



Part No: D4379-1

Job Qty: 30 ea

Part Name: Wearplate Cup



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/1/18

Job Tracking No:

Due Date: 8/13/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV D SHEET 1 IPP REV:A NEW ISSUE 11-04-13 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea		8/13/18	0.00	0.00	Start Up Machining-3		
100	Doosan	30 pcs		8/13/18	0.00	3.83	Doosan		
120	QC	30 pcs		8/13/18	0.00	0.00	QC8		
130	Packaging	30 pcs		8/13/18	0.00	0.00	Packaging3-2		
140	QC21-SA	30 Ea		8/13/18	0.00	0.00	QC21		

Part Op 100 - turn as per Dwg and folio FB057

Descriptions: 130 - LOCATION: WA002

SEP 17 2018
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304RO.750	304 SS Roundbar .750	1.5000 ft (.05 ea)	90-Start up Operation	503397

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304RO.750	2	28	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	.267
2	Wearplate	0.507Inches ± 0.010	0.517 0.497	.508	
3	Wearplate	0.233Inches ± 0.010	0.243 0.223	.2335	
4	Wearplate	0.466Inches ± 0.010	0.476 0.456	.467	
5	Wearplate	0.625Inches + 0.000 - 0.005	0.625 0.620	.6235	
6	Wearplate	0.200Inches ± 0.010	0.210 0.190	.2005	
7	Wearplate	0.438Inches ± 0.010	0.448 0.428	.439	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

8	Wearplate	0.030Inches $\pm$ 0.100	0.130 (0.070)	$\frac{1}{32}$
9	Wearplate	45.000Degrees $\pm$ 0.000	45.000 45.000	45° Angle

Plex 8/1/18 7:59 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		

Root Cause		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : ☐

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Container No: S110384



Part: D4379 - 1

Job No: 181571

Serial No/Batch: S110384

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/16/18